Work Ordo Wednesday, Aug							÷		Pag
Item ID: Revision ID:	D3910-3			Accept				Setup Start	
Item Name: Start Date: Required Date: Reference:	Crosstube Lug 8/4/2010 8/11/2010	Start Qty: 8.00 Req'd Qty: 8.00	1148	II	Cust Iten Custome	I		Stop	
Approvals:	Process Pla	in: ME	Date: <u>\\\</u>	8-0식 Tooling: SPC (Y/N)):	Date:Date:		Run Start Stop	J HEBRICH DENS SPÉTION IN
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Ho			an Accep	ot Reject Qty	Reject Insp. Number Stamp
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D3910	В			0.00	•	<u> </u>	8	B	
Bandsaw Jeaspa Bandsaw		Memo Cut to 1.4	50" Long□	0.00	& \$ 10/08/c) 8 	,		
110 	al machine #1	Memo MACHIN FOLIO R DWG RE	EV. 44 V. B	0.00 0.00 FA865 AND DWG	SF,0/08/68		. <u>8</u>	8_	

W/O:		*****	WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cat	tegory:	_ NCR: Yes	No D G	QA: Date:					
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DATE	STEP	Description of NC	1-242-4	tion B		ication	Approval	Approval				
DAIL	J	Section A	Initial Chief Eng	Action Description Chief Eng	Dat		tich C	Chief Eng	QC Inspector			
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Wednesday, August 04, 2010 1:32:42 PM Item ID: D3910-3 Accept Setup Start **Revision ID:** Stop **Item Name:** Crosstube Lug **Start Date:** 8/4/2010 Start Qty: 8.00 Cust Item ID: Required Date: 8/11/2010 Req'd Qty: 8.00 Customer: Reference: Start Run Date: Process Plan: _____ Date: Tooling: Approvals: Stop Date: _____ SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Description **Work Center ID** Run Hours Qty Qty Code Number Stamp 120 QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 Memo Quality Control QC8- Inspect parts - second check 0.00 130 QC 0.00 Memo

140

HandFinish

Hand Finishing

Quality Control

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Dart Aerospace Ltd

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W/O:			WORK ORDER CHANGES							
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DATE	STEP	Description of NC	Corrective Action Section			1 1		tion	Approval	Approval
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NOTE: Date & initial all entries

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170

Packaging

Packaging

Memo

0.00

0.00

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE **STEP** PROCEDURE CHANGE By Qty **Date** Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval STEP** DATE Sign & **Action Description** Initial Section C QC Inspector Section A Chief Eng Date Chief Eng Chief Eng

Work Order ID 61057

Wednesday, August 04, 2010 1:32:42 PM



Page 4

Item ID:

D3910-3

Accept

Setup Start



Revision ID:

Item Name: Crosstube Lug

Required Date: 8/11/2010

Start Date:

8/4/2010

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Date:

QC21- Final Inspection - Work Order Release

Memo

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run

Stop

Start

Stop

Sequence ID/

Work Center ID

180

Quality Control

Operation

Description

Date: _____

0.00

0.00

Tool # Plan

Accept Code Qty

Reject Reject Qty

Insp. Number Stamp

10-8-11

W/ O:			W	ORK ORDER CHANG	SES					
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Picklist Print

Wednesday, August 04, 2010 1:32:41 PM

Work Order ID: 61057

Parent Item: D3910-3

Parent Item Name: Crosstube Lug

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Start Date: 8/4/2010

Required Date: 8/11/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	380.3221	0.13	1.094737			
				Location		Loc C	Oty	Loc Code	0				
				MAT06		380.3220	0795		<u> </u>				
					43722 45800	200.322	180		<i>-</i>	<u>७१५८</u>	2 8	> 10lc	nx/ax

IPP

Page 1

Dart Aerospace Ltd

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DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	1	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:			Disposition	:	_ QA: N/C	Clos	ed:		Date: _	
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DART AEROSPACE LTD	Work Order:	6057
Description: Crosstube Lug	Part Number:	D3910-3
Inspection Dwg: D3910 Rev: B		Page 1 of 1

Drawing Dimension				1	FIRST ARTICLE INSPECTION CHECKLIST											
D	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments										
4.45	+/-0.030	4.453	/		Very St	12_										
1.38	+/-0.030	1.386			1)											
R0.080	+/-0.020	.080			Rad sayse											
0.27 Ref	+/-0.030	.272			High gave	1										
0.31	+/-0.030	.306														
0.735 Ref	+/-0.010	727			V											
R1.20	+/-0.030	1.200	1		vers 5 8 pg											
3.700	+/-0.010	3.700	/		t,											
0.375	+/-0.010	.375	/		17											
0.625	+/-0.010	-623	/		77											
0.375	+/-0.010	. 375	/		<i>'</i> ,											
R0.34	+/-0.030	.034	/		Radgaras											
Ø0.257	+0.006/-0.001	-257	/		V											
0.100 x 45°	+/-0.010 x +/-0.5°	100	/		1											
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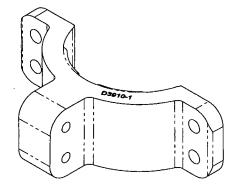
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Rev	Date	Change				Revi	sed by	Approved
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Dail Ae	ospace							•			
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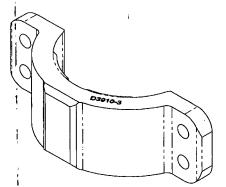
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D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

RELEASED 2010 -03- 22

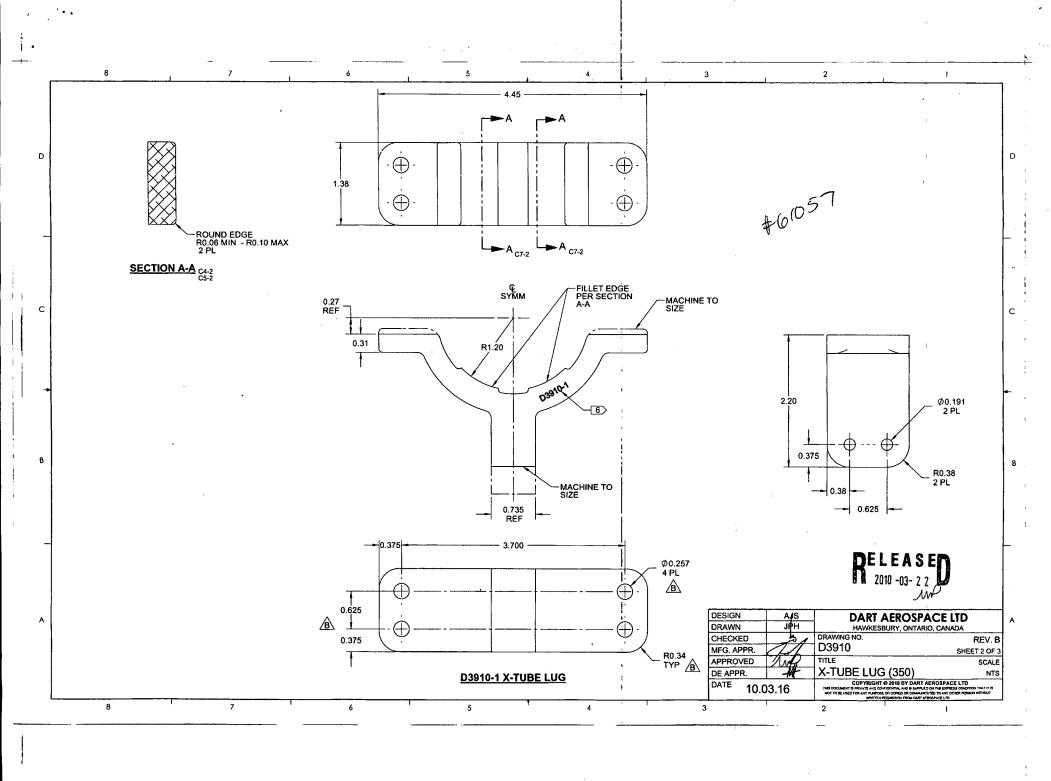
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Α	NEW IS				JPH	10.03.04		
REV.				DESCRIPTION	BY	DATE		
DESIGN AJS			JS	DART AEROSPACE LTD				
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MFG, APPR.		: Z	7/	D3910		SHEET 1 OF 3		
APPROVED		Not	1/1	TITLE		SCALE		
DE APPR.		4	-	X-TUBE LUG (350)		NTS		
DATE 10.03.16				COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COCUMENT OF PRIVATE AND CONFEDENTIAL AND IS REPTUDD ON THE EXPRESS CONSTRONTIALT IT IS THE TO BE LITERATED AND RESIDENCE OF COMMAND AND CONTROL THE PRIVATE AND AND THE PRIVATE AND AND THE PRIVATE AND AND THE PRIVATE AND AND THE PRIVATE AND				

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

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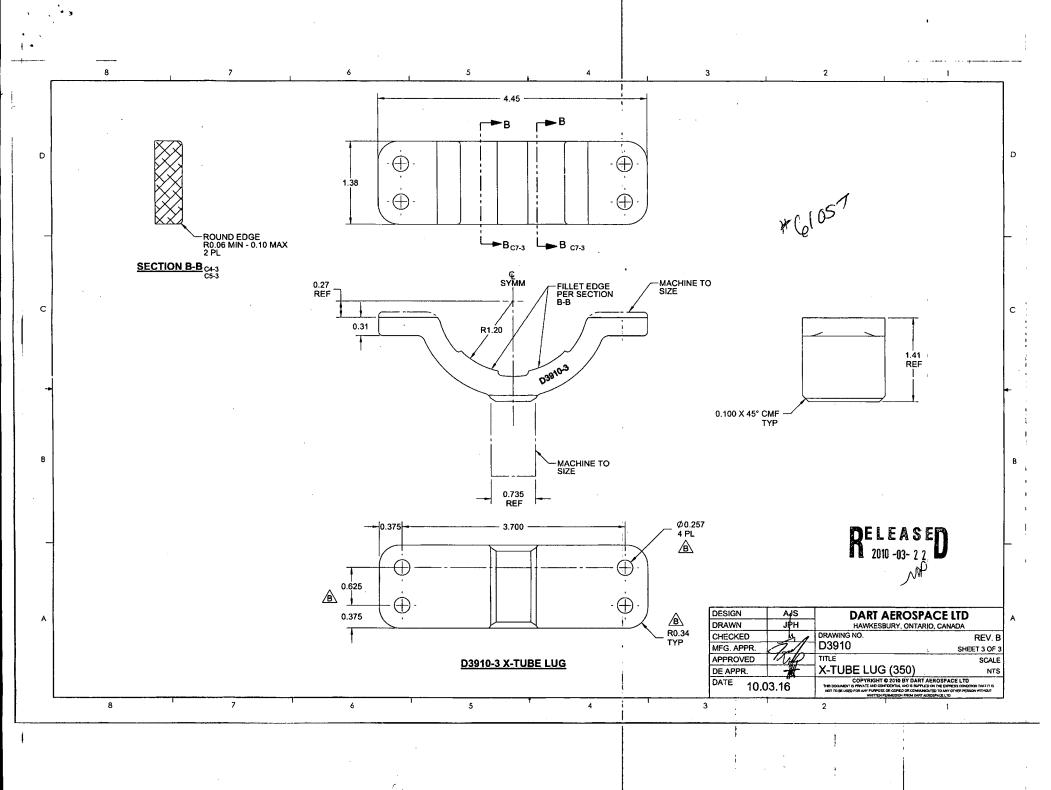
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W/O:		WORK ORDER CHANGES								•
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** PROCEDURE CHANGE DATE **STEP** By Date **Dty** Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section C QC Inspector Section A Chief Eng Date Chief Eng Chief Eng